

CLAIM:

1. A method of surface treating a cookware article formed of aluminium or aluminium alloy, comprising the steps of:
 - a) applying a first coating of porcelain enamel to the exterior of the article;
 - b) subjecting the interior of the article to hard-anodizing; and
 - c) applying a second coating of porcelain enamel over the first coating.
2. A method according to claim 1 wherein the porcelain enamel is applied as a porcelain slip which is cured at an elevated temperature.
3. A method according to claim 2 wherein the second porcelain enamel coating is subjected to curing at a temperature which is sufficient to at least partially remelt the surface of the first porcelain enamel coating.
4. A method according to claim 1 wherein the first porcelain enamel coating is applied as a layer of thickness in the range 25 to 35 microns.
5. A method according to claim 1 wherein the second porcelain enamel coating is applied as a layer of thickness in the range 30 to 35 microns.
6. A method according to claim 1 wherein the second

5
Sub B13

10

15

Sub B13

20

Sub B13

25

Sub B13

porcelain enamel coating is subjected to rapid drying using infra-red heating means to dry the enamel surface, followed by silkscreen printing of a pattern onto the dried surface.

- 5 7. A method according to claim 1 wherein the first porcelain enamel is heated to curing at a temperature in the region of 540 to 555°C.

- Sub
10 B13 8. A method according to claim 7 wherein said curing is carried out for 1 to 1.5 minutes.

9. A method according to claim 1 wherein at step b) the interior of the article is subjected to anodizing for less than 20 minutes.

- 15 10. A method according to claim 1 wherein the hard-anodized interior of the article is coated with a non-stick coating.

11. A method of forming an article of cookware of aluminium or aluminium alloy, comprising the steps of:

- Sub
20 B13 i) providing a disc-like blank of flat metal;
ii) forming the article by stamping into the desired shape;
iii) applying a first coating of porcelain slip to the exterior of the article of thickness in the range 25 to 35 microns and curing at an elevated temperature to produce a hard enamel;
25 iv) subjecting the interior surface to hard-

Sub ~~B13~~
B13
5

- sub
10 B13¹³

13. An article of cookware when formed according to the method of claim 11.

- 15

15. An article of cookware according to claim 14 wherein the total thickness of the porcelain enamel coating is in the range 60 to 70 microns.